

Work Order ID 136322

September 02, 2015 11:11:57 AM

136322

Page 1

Item ID: D4784-011 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Basket Assembly, Heavy Duty Lid, LH/RH
Start Date: 9/2/2015 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 9/23/2015 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: 54 Date: 0150902 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4784	D								
100	Pick Kit	0.00							
100									
Packaging	Memo	0.00							
Packaging									
110	Assemble as per dwg	0.00							
110									
HandFinish	Memo	0.00							
Hand Finishing	Transfer drill from D4687-210 to label plate as per dwg. Install as per dwg.								
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							
Quality Control									

1x SP15-09-181x CC 15-9-181 DAS
38
9-89
SEP 18 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐								
		OTHER : _____							

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Accept

Setup Start *NS1*

Stop *NS2*

Start Date: 9/2/2015 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 9/23/2015 **Req'd Qty:** 1.00 ***1***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run	Start	*NR1*
	Stop	*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Identify as per dwg & Stock Location:

0.00

130

Packaging

Memo

0.00

Packaging

DAE
66
9-89

SEP 17 2015

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

MCQ

SEP 21 2015

ML5

SEP 21 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																
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Picklist Print

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Page 1

Work Order ID: 136322

136322

Parent Item: D4784-011

D4784-011

Parent Item Name: Basket Assembly, Heavy Duty Lid, LH/RH

Start Date: 9/2/2015

Required Date: 9/23/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 13.03.18 NEW ISSUE DD VERF:JLM IPP
REV:B 13.06.17 as per dwg rev.A DD VERF:JLM IPP REV:C
13.06.17 as per dwg rev.pb1 DD VERF:JLM IPP REV:D 13.06.21
DWG REV.B DD VERF:JFS IPP REV:E 13.12.02 DWG
REV.C DD VERF:JLM IPP REV:F 15.01.19 DWG REV.pd1
DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

97447A010		Purchased	No				Each	224.0000		4			
97447A010									**				
Blind Rivet													

				<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>	
				ST564	224		
				m131311	224		
D2530		Manufactured	No		Each	2.0000	

D2530

Handle Weldment

				<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>	
				ST379	2		
				115580	2	13136095	
D2535		Manufactured	No		Each	60.0000	

D2535

Spring

				<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>	
				ST007	1		
				124521	1		
				ST008	59		
				131996	9		
				134782	50		

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Work Order ID: 136322

136322

Parent Item: D4784-011

D4784-011

Parent Item Name: Basket Assembly, Heavy Duty Lid, LH/RH

Start Date: 9/2/2015

Required Date: 9/23/2015

Start Qty: 1.00

Required Qty: 1.00

D2537 Manufactured No

Each 50.0000 2

D2537

Bushing

all 12/09/17

Location

Loc Qty

Loc Code

ST008

50

113174

2

123463

7

131896

1

132664

20

134935

20

X2

D3914-041 Manufactured No

Each 0.0000

D3914-041

Long Basket Lid Assembly (350)

13136450 (12) all 12/09/17

D3917-3 Manufactured No

Each 41.0000

D3917-3

Washer

all 12/09/17

Location

Loc Qty

Loc Code

ST065

41

121801

1

128455

16

133951

24

X6

D3953-3 Manufactured No

Each 24.0000

D3953-3

Gas Spring Stud, Lid

all 12/09/17

Location

Loc Qty

Loc Code

ST069

4

124029

3

131922

1

ST077A

20

122668

10

131080

6

132707

4

B122668

X2

Picklist Print

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Work Order ID: 136322

136322

Parent Item: D4784-011

D4784-011

Parent Item Name: Basket Assembly, Heavy Duty Lid, LH/RH

Start Date: 9/2/2015

Required Date: 9/23/2015

Start Qty: 1.00

Required Qty: 1.00

D3953-7 Manufactured No

Each 54.0000 2

D3953-7

Spring Spacer

all 15/09/17

Location

Loc Qty

Loc Code

ST069

54

120351

4

121813

6

130996

16

131859

12

135499

16

x2

D3953-9 Manufactured No

Each 32.0000 2

D3953-9

Gas Spring Washer

all 15/09/17

Location

Loc Qty

Loc Code

ST069

32

131057

22

132672

10

x2

D3953-17 Manufactured No

Each 26.0000 2

D3953-17

Gas Spring Spacer

all 15/09/17

Location

Loc Qty

Loc Code

ST070

26

115708

4

129797

10

132522

12

x2

D3953-19 Manufactured No

Each 23.0000 1

D3953-19

Gas Spring Bracket

all 15/09/17

Location

Loc Qty

Loc Code

ST070

23

118893

5

131776

18

x1

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Shop Packet Print

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Work Order ID: 136322

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Parent Item: D4784-011

D4784-011

Parent Item Name: Basket Assembly, Heavy Duty Lid, LH/RH

Start Date: 9/2/2015

Required Date: 9/23/2015

Start Qty: 1.00

Required Qty: 1.00

D3953-21

Manufactured No

Each

47.0000

1

D3953-21

Gas Spring Bracket

all 12/09/13

Location

Loc Qty

Loc Code

ST070

47

117496

3

128883

16

132602

28

X1

D3969-3

Manufactured No

Each

23.0000

1

D3969-3

Prop

all 12/09/13

Location

Loc Qty

Loc Code

ST365

23

115924

8

133104

5

135397

10

X1

D4785-041

Manufactured No

Each

0.0000

1

D4785-041

Long Basket Base Assembly, LH/RH

B136327(1) all 12/09/13

D4786-210

Manufactured No

Each

3.0000

1

D4786-210

Placard, Max Load

SP1509-8

Location

Loc Qty

Loc Code

ST127

3

128577

3

/X

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D4784-011

Parent Item Name: Basket Assembly, Heavy Duty Lid, LH/RH

Start Date: 9/2/2015

Required Date: 9/23/2015

Start Qty: 1.00

Required Qty: 1.00

AN3-14A	Purchased	No	Each	127.0000	4	**	<u>all 15/09/15</u>
AN3-14A							
Bolt							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST338a	100	
m132825	100	
ST348	27	
m132680	27	X4

AN3-16A	Purchased	No	Each	95.0000	2	**	<u>all 15/09/15</u>
AN3-16A							
Bolt							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
GA	45	
117441	45	
ST348	50	
M133011	50	X7

AN310C4	Purchased	No	Each	62.0000	2	**	<u>all 15/09/15</u>
AN310C4							
Nut							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST331	62	
M131305	12	X2
M132344	50	

AN310-4	Purchased	No	Each	97.0000	3	**	<u>all 15/09/15</u>
AN310-4							
Nut							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
GA	25	
M127815	25	
ST331	72	
M132382	72	X3

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D4784-011

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Start Date: 9/2/2015

Required Date: 9/23/2015

Start Qty: 1.00

Required Qty: 1.00

AN4-12 Purchased No

Each 67.0000 3

AN4-12

all 15/09/14

Bolt

Location

Loc Qty

Loc Code

ST325A

20

m128813

20

X3

ST344

47

m132317

47

AN5-17A Purchased No

Each 144.0000 4

AN5-17A

all 15/09/14

Bolt

Location

Loc Qty

Loc Code

GA

36

117872

36

ST299A

100

m132317

50

m133077

50

X1

ST337

8

125388

8

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Start Date: 9/2/2015

Required Date: 9/23/2015

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

Each

1,033.000

6

MS21042L3

Handwritten: 10/09/17

Nut

Location

Loc Qty

Loc Code

FP001

384

M130922

384

Handwritten: 113313V

Handwritten: X6

GA

227

M131317

227

ST305

422

116549

12

126333

49

M128754

2

M132123

17

M132382

2

M132883

17

M132930

323

MS21042L5

Purchased

No

Each

539.0000

4

MS21042L5

Handwritten: 10/09/17

Nut

Location

Loc Qty

Loc Code

GA

146

m127813

146

ST260a

345

m132677

345

ST305

48

Handwritten: X4

m127813

19

m131340

21

m132123

8

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Parent Item Name: Basket Assembly, Heavy Duty Lid, LH/RH

Start Date: 9/2/2015

Required Date: 9/23/2015

Start Qty: 1.00

Required Qty: 1.00

MS24665-151

Purchased

No

Each

164.0000

3

MS24665-151

Cotter Pin

all 10/09/17

Location

Loc Qty

Loc Code

GA

59

m128401

59

ST294

105

m128401

9

m129909

96

x3

MS24665-300

Purchased

No

Each

139.0000

2

MS24665-300

COTTER PIN

all 10/09/17

Location

Loc Qty

Loc Code

GA

30

118234

30

ST293

109

M128812

109

x2

NAS1149F0332P

Purchased

No

Each

1,913.000

8

NAS1149F0332P

Washer

all 10/09/17

Location

Loc Qty

Loc Code

GA

210

122063

210

ST260a

1610

m128401

6

m131026

80

m131697

524

m133077

1000

st268

93

10

123900

7

m130388

86

September 02, 2015 11:12:04 AM

Shop Packet Print

Page 8

Picklist Print

Page 9

September 02, 2015 11:12:04 AM

Work Order ID: 136322

136322

Parent Item: D4784-011

D4784-011

Parent Item Name: Basket Assembly, Heavy Duty Lid, LH/RH

Start Date: 9/2/2015

Required Date: 9/23/2015

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0432R

Purchased

No

Each

1,597.000

2

NAS1149C0432R

WASHER

lll 15/09/17

Location

Loc Qty

Loc Code

GA

1586

m125807

476

m131467

1110

v2

ST271

11

m131452

11

NAS1149F0432P

Purchased

No

Each

954.0000

6

NAS1149F0432P

WASHER

lll 15/09/17

Location

Loc Qty

Loc Code

ST260a

500

M132551

500

st268

454

M128995

63

M130388

8

M132677

383

x6

NAS1149F0563P

Purchased

No

Each

125.0000

4

NAS1149F0563P

Washer

lll 15/09/17

Location

Loc Qty

Loc Code

ST267

25

121350

25

x4

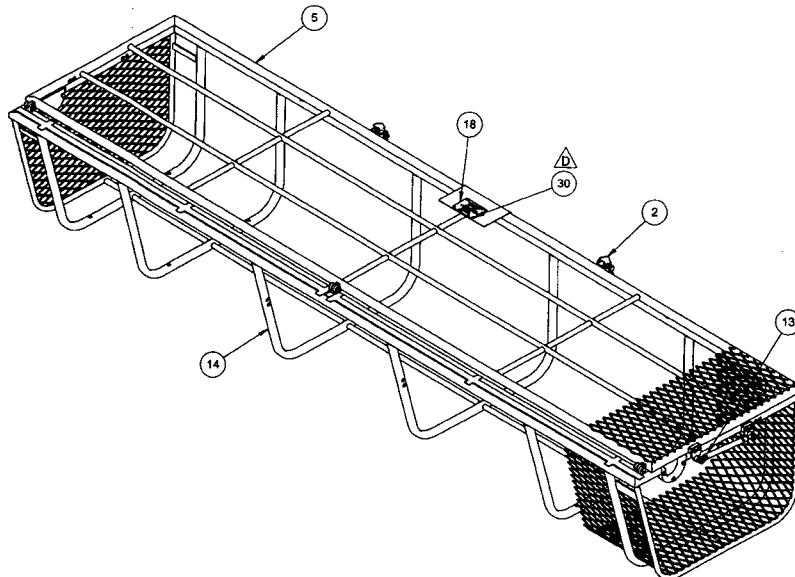
st268

100

m132344

100

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D4784-011	BASKET ASSY, HEAVY DUTY LID, LH/RH
2	1	D2530	HANDLE WELDMENT
3	2	D2535	SPRING
4	2	D2537	BUSHING
5	1	D3914-041	LONG BASKET LID ASSY (350)
6	6	D3917-3	WASHER
7	2	D3953-3	GAS SPRING STUD, LID
8	2	D3953-7	GAS SPRING SPACER
9	2	D3953-9	GAS SPRING WASHER
10	2	D3953-17	GAS SPRING SPACER
11	1	D3953-19	GAS SPRING BRACKET
12	1	D3953-21	GAS SPRING BRACKET
13	1	D3969-3	SPRING
14	1	D4785-041	LONG BASKET BASE ASSY, LH/RH
18	1	D4786-210	PLACARD, MAX LOAD
16	4	AN3-14A	BOLT
17	2	AN3-16A	BOLT
18	2	AN310C4	NUT, CASTELLATED
19	3	AN310-4	NUT, CASTELLATED
20	3	AN4-12	BOLT
21	4	AN5-17A	BOLT
22	6	MS21042L3	NUT, SELF-LOCKING
23	4	MS21042L5	NUT, SELF-LOCKING
24	3	MS24685-151	COTTER PIN
25	2	MS24685-300	COTTER PIN
26	8	NAS1149F0332P	WASHER
27	2	NAS1149C0432R	WASHER
28	6	NAS1149F0432P	WASHER
29	4	NAS1149F0563P	WASHER
30	4	97447A010	BLIND RIVET, PAN HEAD



D4784-011 BASKET ASSEMBLY HEAVY DUTY, LH/RH
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED

2015 MAR 16
4 ECH 15-730

SH
136322
20150902

D	ADDED 97447A010 (ZN B6-1 & C3-2)	RF	15.01.13
C	REVISE D3969-3 QTY (ZN C8-1); REF PAR13-315	RF	13.11.25
B	REVISE D4785-041 SHOWN	RF	13.08.11
A	NEW ISSUE	RF	13.05.24

REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED	VS		
MFG. APPR.	DD		
APPROVED	HS		
DE APPR.	DS		
DATE	15.01.13		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4784** REV. D
SHEET 1 OF 3

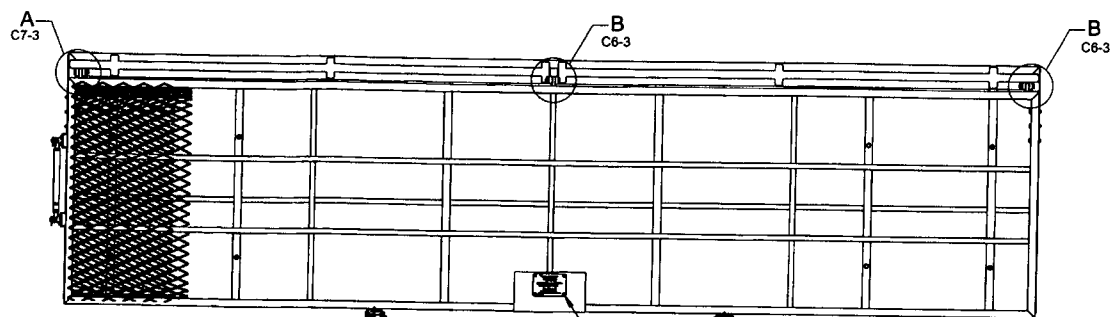
TITLE **BASKET ASSEMBLY** SCALE NTS

DATE 15.01.13

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NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 80.10 LBS

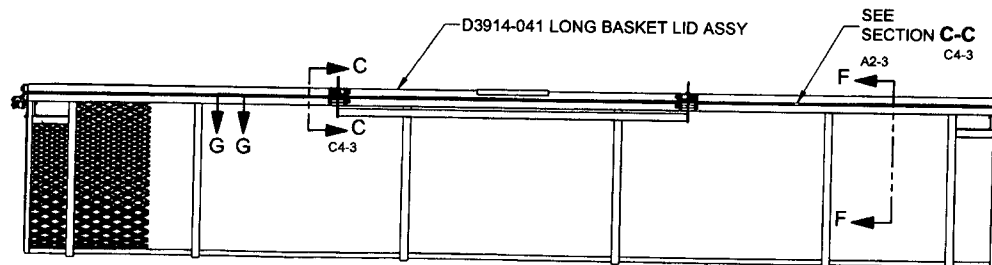
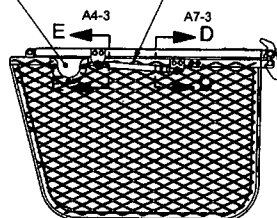


D2530
HANDLE WELDMENT

TRANSFER DRILL #30 HOLES
INSTALL D4786-210 PLACARD USING
97447A010 BLIND RIVET, 4 PL

D4021-5
BLANKING PLATE
REF, SEE SECTION F-F

D3969-3 GAS SPRING



D4785-041 LONG BASKET BASE ASSY

D2931 BUMPER
NAS1149DN832J WASHER
MS20600AD4W3 RIVET



SECTION G-G
(LID ASSY REMOVED FOR CLARITY)

D4784-011 BASKET ASSEMBLY HEAVY DUTY, LH/RH
(MESH SHOWN LOCALLY OR REMOVED FOR CLARITY)

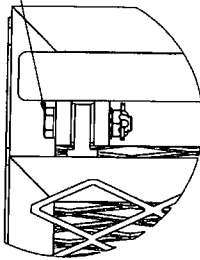
RELEASED

2015 MAR 16

APPROVED

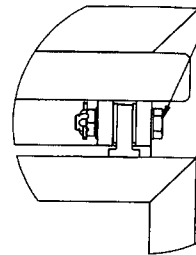
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	VS	DRAWING NO.	REV. I
MFG. APPR.	DD	D4784	SHEET 2 OF 3
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	BASKET ASSEMBLY	NT
DATE	15.01.13	COPYRIGHT © 2013 BY DART AEROSPACE LTD	
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AN4-12 BOLT
D3917-3 WASHER, 2X
NAS1149F0432P WASHER, 2X
AN310-4 NUT, CASTELLATED
MS24665-151 COTTER PIN



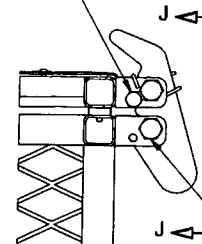
DETAIL A D6-2

AN4-12 BOLT
D3917-3 WASHER, 2X
NAS1149F0432P WASHER, 2X
AN310-4 NUT, CASTELLATED
MS24665-151 COTTER PIN



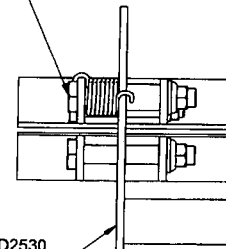
DETAIL B D2-2
D4-2

AN3-16A
MS21042L3 NUT



SECTION C-C B5-2
B3-2

AN5-17A BOLT
D2537 BUSHING
D2535 SPRING
NAS1149F0563P WASHER
MS21042L5 NUT



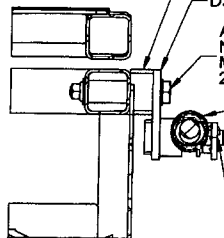
D2530
HANDLE WELDMENT
REF

VIEW J-J

D3953-17 GAS SPRING SPACER
D3953-21 GAS SPRING BRACKET

AN3-14A BOLT
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
2 PL

D3969-3 GAS SPRING
REF

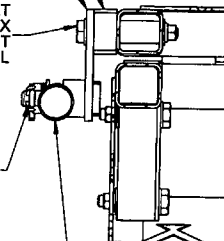


SECTION D-D B7-2

D3953-17 GAS SPRING SPACER
D3953-19 GAS SPRING BRACKET

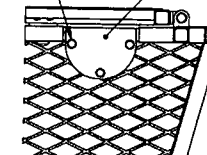
AN3-14A BOLT
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
2 PL

D3953-3 GAS SPRING STUD, LID
D3953-7 GAS SPRING SPACER
D3953-9 GAS SPRING SPACER
NAS1149C0432R WASHER
AN310C4 NUT, CASTELLATED
MS24665-300 COTTER PIN



SECTION E-E B7-2

AN3-10A BOLT
NAS1149F0332P WASHER
MS21042L3 NUT
3 PL, REF



D4021-5
BLANKING PLATE
REF

SECTION F-F B2-2

RELEASED

2015 MAR 16 *q*

APPROVED

DESIGN	RF
DRAWN	RF
CHECKED	VS
MFG. APPR.	DD
APPROVED	HS
DE APPR.	DS
DATE	15.01.13

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4784	REV. D SHEET 3 OF 3
TITLE BASKET ASSEMBLY	SCALE NTS
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